

Work Order ID 136156

Friday, August 28, 2015 1:57:24 PM

136156

Page 1

Item ID: 646.3301

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Cutter Assy

Start Date: 8/31/2015 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 8/31/2015 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: SH/LL Date: 20150831 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3300	NC3

110	Pick Kit	0.00							
110									
Packaging	Memo	0.01							
Packaging									

DAS
30
9-89

SEP 10 2015

120		0.00							
120									
Small Fab	Memo	0.05							
Small Fab	TWO fastener must be install finger-tight (see note 9)								

DAS
36
9-89

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598: 1133275
exp. date: 05/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 136156

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Item ID: 646.3301 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assy
Start Date: 8/31/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/31/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						(5)			
QC	Memo	0.01							
Quality Control									OCT 19 2015
140	Identify as per dwg & Stock Location: <u>cc k 018</u>	0.00							
140						S			DAS 27 9-89
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
									OCT 20 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control						MLJ			OCT 21 2015

S/A 0151020

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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Page 1

136156

646 3301

Required Date: 8/31/2015

Required Qty: 5.00

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310		Manufactured	No			110	Each	12.0000	1	5	DAS 30 9-89		
646 3310													
LH Half													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				12					
					124425			9					
					125832			3					
646.3311		Manufactured	No			110	Each	6.0000	1	5	DAS 30 9-89		
646 3311													
RH Half													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF3				6					
					125166			2					
					131608			4					
646.3312		Manufactured	No			110	Each	13.0000	1	5	DAS 30 9-89		
646 3312													
Center Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				13					
					125437			8					
					125852			5					
646.3313		Manufactured	No			110	Each	1.0000	1	5	DAS 30 9-89		
646 3313													
Upper Guide													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck102				1					
					131609			1					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 136156

136156

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/31/2015

Required Date: 8/31/2015

Start Qty: 5.00

Required Qty: 5.00

646.3314 Manufactured No

110 Each 6.0000 1 5

DAS

SEP 10 2015

646 3314

Blade

**

30

9-89

Location

Loc Qty

Loc Code

MF

6

127669

6

646.3315 Manufactured No

110 Each 2.0000 1 5

DAS

SEP 10 2015

646 3315

Blade

**

30

9-89

Location

Loc Qty

Loc Code

MF

2

131610

2

646.3316 Manufactured No

110 Each 0.0000 1 5

DAS

646 3316

Blade

1

5

30

9-89

B 135465**

DAS

NAS1149FN832P

Purchased No

110 Each 2,488.000 36 180

30

9-89

NAS1149FN832P

Washer

B 134170 **

SEP 10 2015

Location

Loc Qty

Loc Code

ST260a

1500

125268

1500

st268

988

125268

67

M130388

921

180

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

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Work Order ID: 136156

136156

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/31/2015

Required Date: 8/31/2015

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

110

Each

896.0000

18

90

DAS

MS21042L 08

30

SEP 10 2015

Nut

9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

106

m131697

106

ST304

689

123900

16

m128401

102

m128429

3

m131317

68

m132930

500

90

NAS1149F0332P

Purchased

No

110

Each

1,037.000

6

30

NAS1149F0332P

DAS

SEP 10 2015

Washer

30

9-89

Location

Loc Qty

Loc Code

GA

210

122063

210

ST260a

734

m128401

6

m131026

80

m131697

648

st268

93

123900

7

m130388

86

30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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OTHER : ☐					

Picklist Print

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Work Order ID: 136156

136156

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/31/2015

Required Date: 8/31/2015

Start Qty: 5.00

Required Qty: 5.00

AN3-12A	Purchased	No	110	Each	44.0000	2	10	DAS	SEP 10 2015
AN3-12A								30	
Bolt								9-89	

Location

Loc Qty

Loc Code

GA
m129682

44
44

M 129507

9

MS21042L3	Purchased	No	110	Each	1,123.000	3	15	DAS	SEP 10 2015
MS21042L3								30	
Nut								9-89	

Location

Loc Qty

Loc Code

FP001
M130922
GA
M131317
ST305
116549
126333
M128754
M132123
M132382
M132883
M132930

384
384
233
233
506
12
49
2
17
2
19
405

15

MS27039-08-19	Purchased	No	110	Each	552.0000	18	90	DAS	SEP 10 2015
MS27039-08-19								30	
Screw								9-89	

Location

Loc Qty

Loc Code

ST273A
m131317
m132930
ST281
m131264

523
273
250
29
29

90

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, August 28, 2015 1:57:28 PM

Page 5

Work Order ID: 136156

136156

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/31/2015

Required Date: 8/31/2015

Start Qty: 5.00

Required Qty: 5.00

AN3-14A

Purchased

No

110

Each

131.0000

1

5

DAS

30

9-89

SEP 10 2015

AN3-14A

Bolt

Location

Loc Qty

Loc Code

ST338a

100

m132825

100

ST348

31

m132680

31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

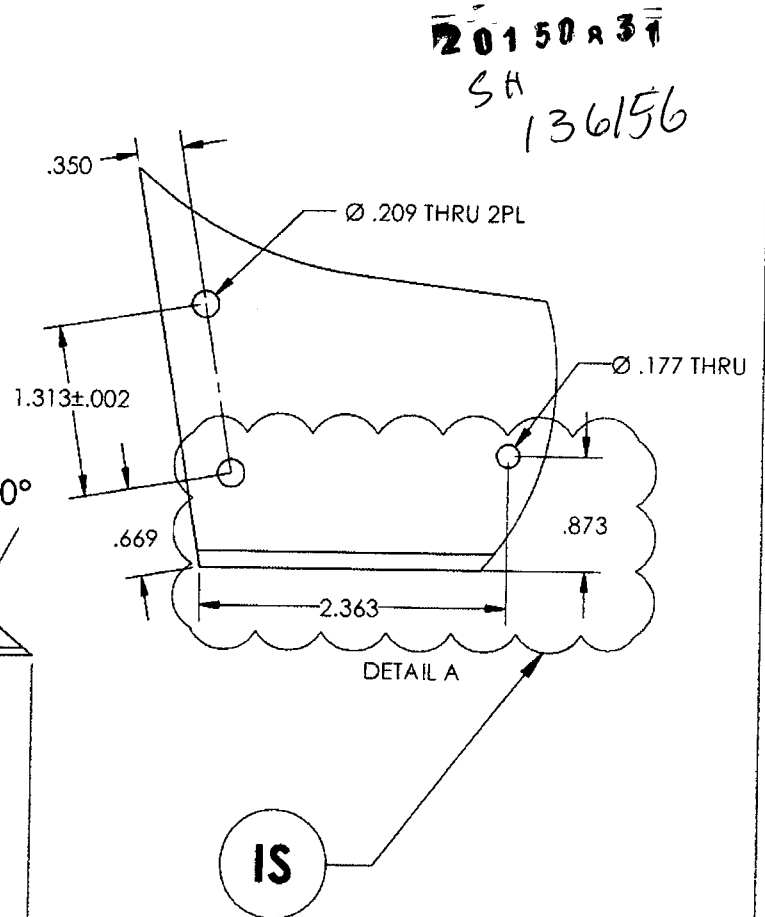
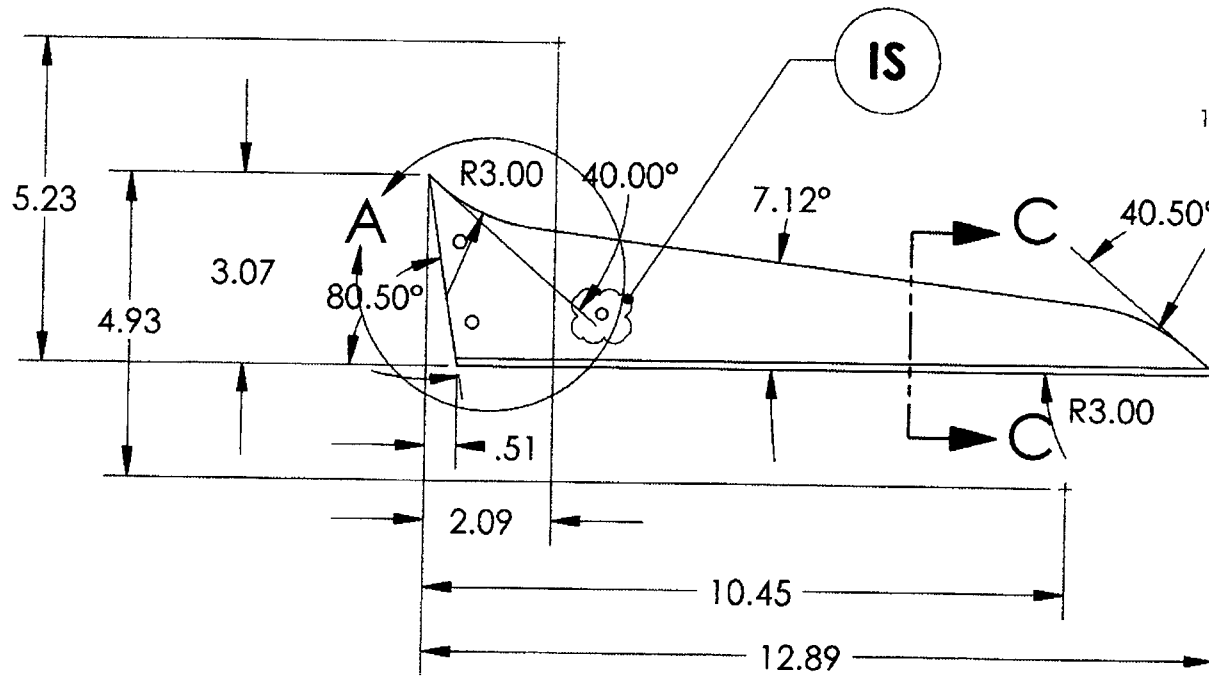
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.		04765		SHEET 1 OF 1	
DWG NO.	646.3300	REV:	NC	PREPARED BY	J. SOTO
DATE:		12/08/2014		EFFECT ON DWG ☐ INC. ☒ UNINC.	
DWG TITLE: UPPER CUTTER ASSY					
APPROVED BY:	ENGR. <i>[Signature]</i>	MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF. NEXT ORDER	
REASON: ADDED HOLE DIMENSION TO 646.3313.					

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

SHEET 5 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY: ENGR

MFG

QC

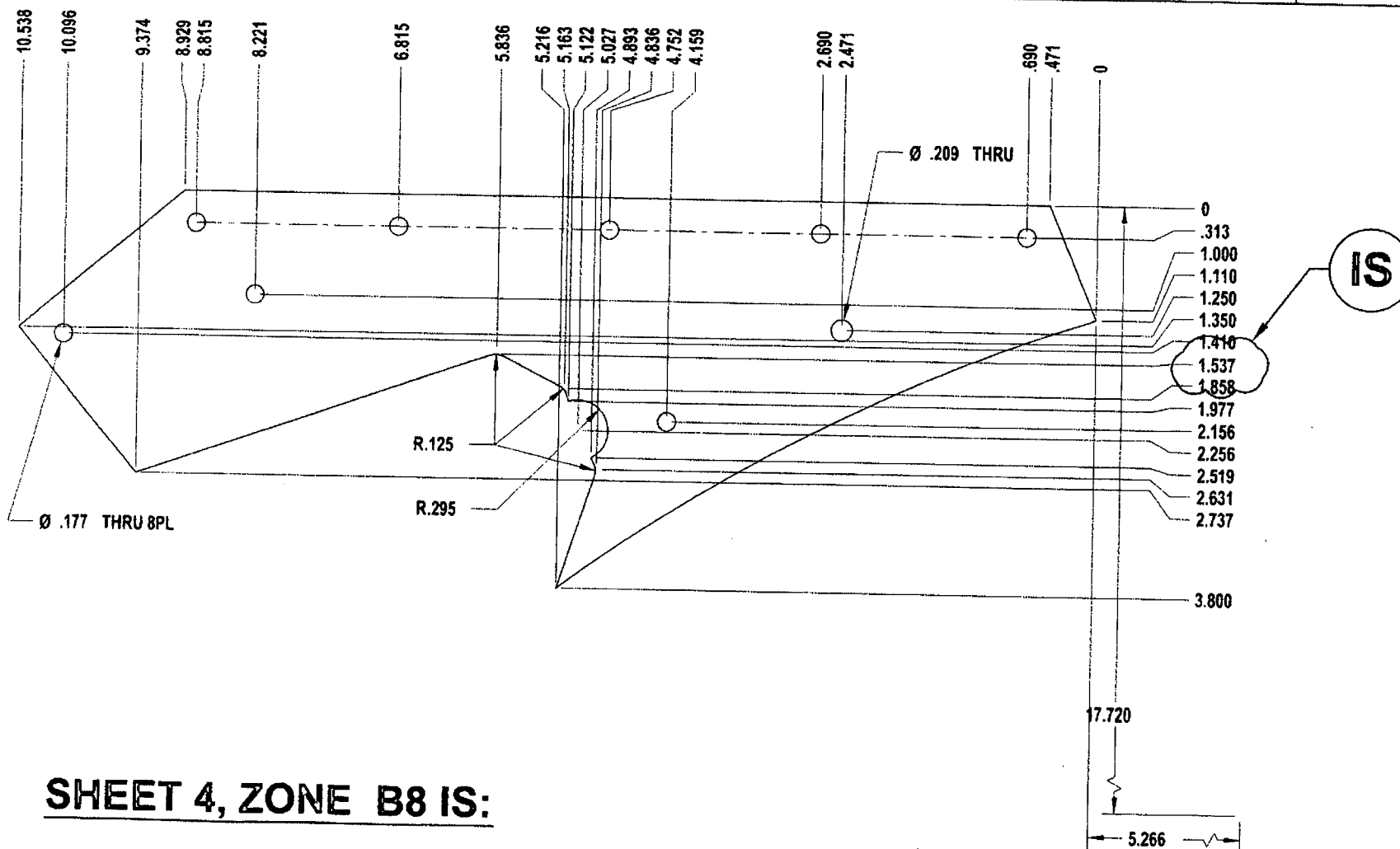
EFF: NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:
D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

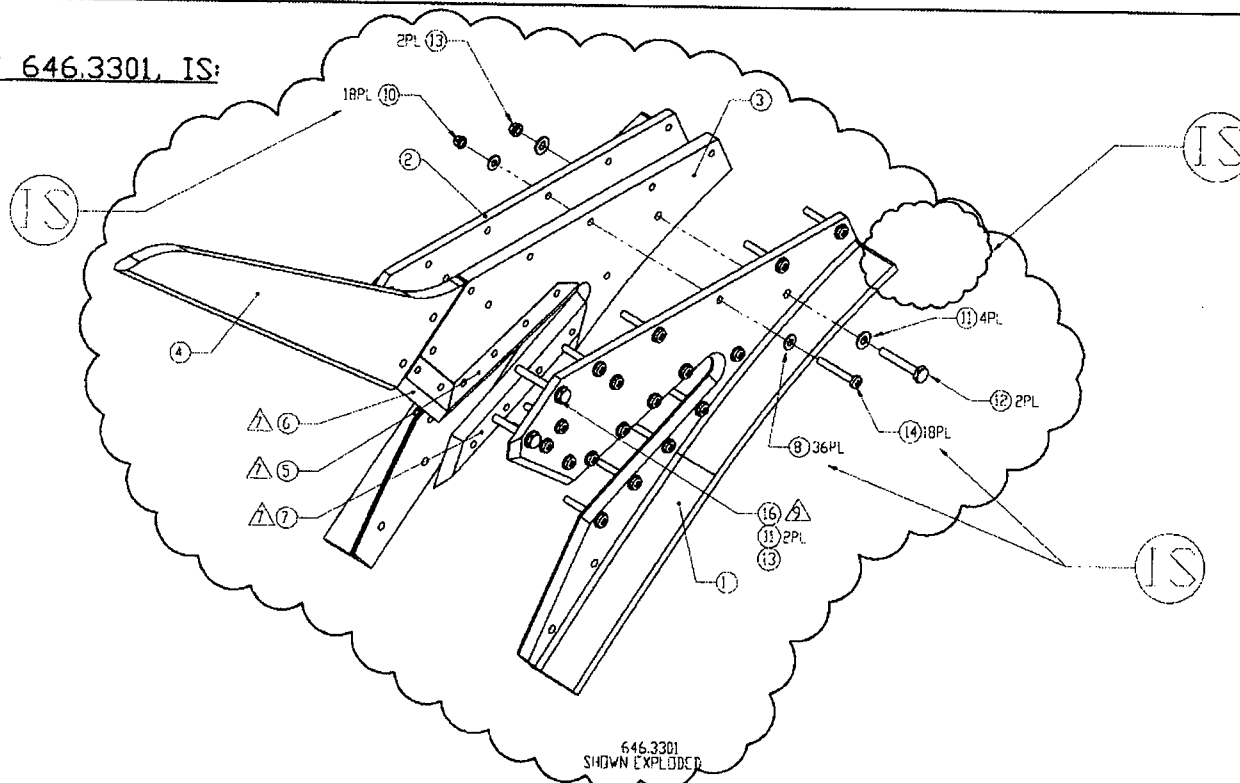
CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

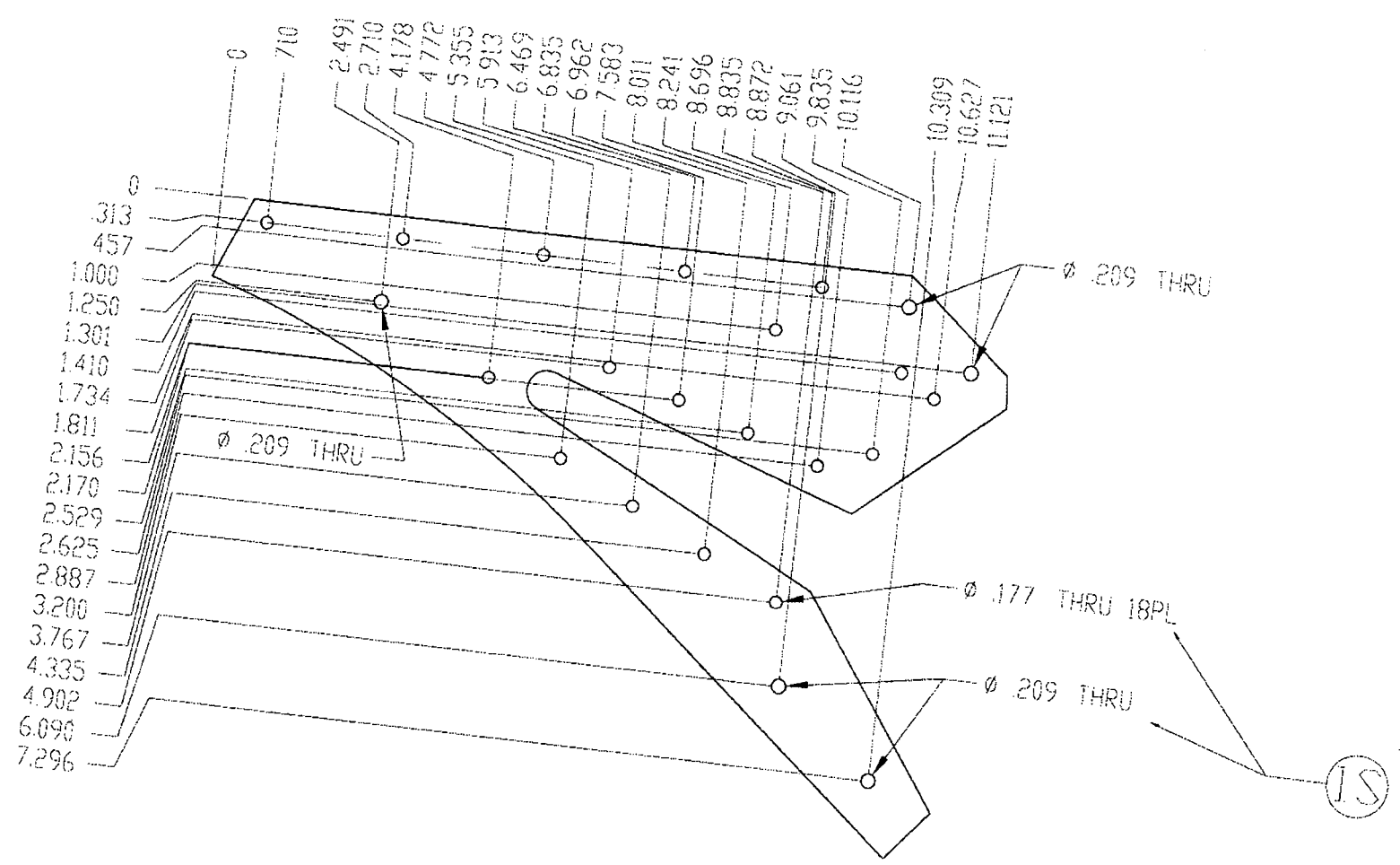
ENGINEERING CHANGE NOTICE NO.		02196		SHEET 1 OF 2	
DWG NO.	646.3300	REV: N/C	PREPARED BY	S. HUFF	DATE: 01/05/09
DWG TITLE:		UPPER CUTTER ASSY			
APPROVED BY:	ENGR <i>[Signature]</i>	MFG	<i>[Signature]</i>	QC	<i>[Signature]</i>
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS					EFFECT ON DWG ☐ INC. ☒ UNINC.
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE					EFF: NEXT ORDER

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3, SECTION VIEW A-A, IS:



SECTION A-A

PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-------------	-----	-------------	------------------------

NOTES:

- 646.3301
SHOWN EXPLODED

[illegible]

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646.3310 SHOWN
646.3311 OPPOSITE

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

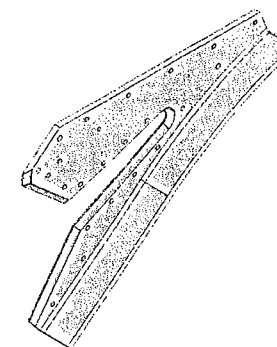
UPPER CUTTER ASSY

SCALE: NONE

1 SHEET 2 OF 8

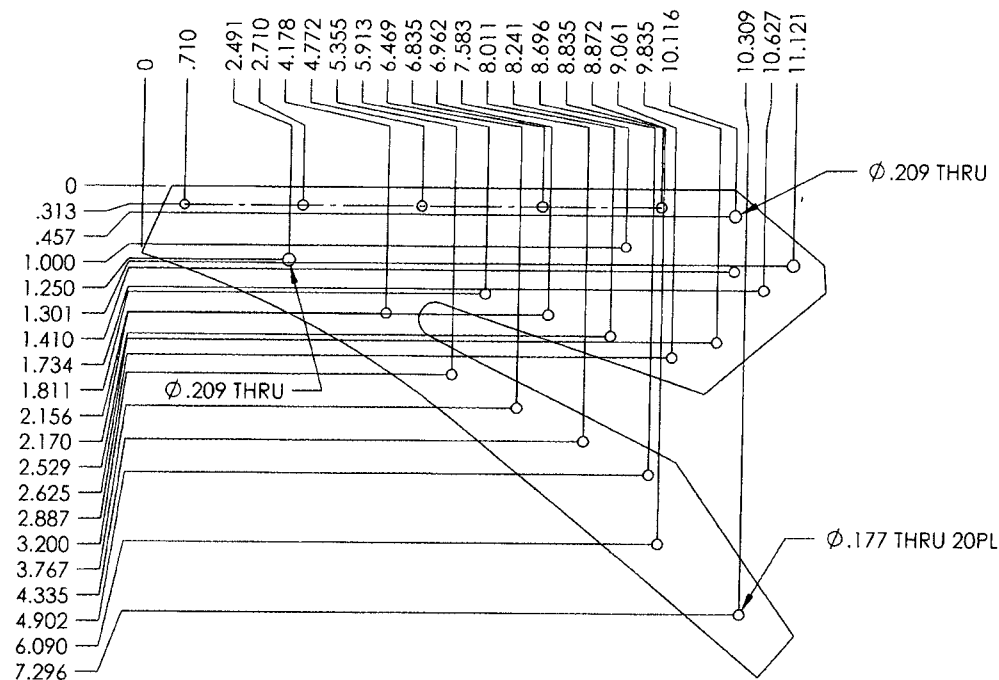
The drawing includes three main views:

- Top View:** Shows the plan view of the cutter assembly. Key dimensions include overall width of .250, a central slot width of 1.250, and various offset distances from the left edge: 11.689, 11.648, 11.250, 10.808, 10.647, 10.116, 9.636, and 9.172. A diagonal feature is defined by an 8.1° angle and a radius R17.375. Other horizontal dimensions are 5.922, 5.046, 4.91, .098, .074, 0, .925, 1.156, 1.180, 1.286, 1.759, 2.256, 3.513, 4.410, 4.689, 7.657, 8.183, 8.375, and 5.246. Section lines B-B and A-A are indicated.
- Side View:** Shows the profile of the assembly with a total height of 17.720. It features a top flange with a thickness of .250 and a fillet with a radius R.125 TYP. Section line A-A is shown.
- Perspective View:** Provides a 3D representation of the part, highlighting its L-shaped profile and mounting holes.



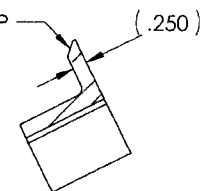
CONCRETE DATE (MO-DA-YR) 08-26-06 DRAWN BY CRITCHER 5-147 DRAWING APPROVAL P. PAVO CONTRACT ALLSOP CONCRETE SPECIFIED CONDITIONS ARE IN ACCORDANCE WITH THE FOLLOWING: 1. ACI 308.3R-02 2. ACI 308.4R-02 3. ACI 308.5R-02 4. ACI 308.6R-02 5. ACI 308.7R-02 6. ACI 308.8R-02 7. ACI 308.9R-02 8. ACI 308.10R-02 9. ACI 308.11R-02 10. ACI 308.12R-02 11. ACI 308.13R-02 12. ACI 308.14R-02 13. ACI 308.15R-02 14. ACI 308.16R-02 15. ACI 308.17R-02 16. ACI 308.18R-02 17. ACI 308.19R-02 18. ACI 308.20R-02 19. ACI 308.21R-02 20. ACI 308.22R-02 21. ACI 308.23R-02 22. ACI 308.24R-02 23. ACI 308.25R-02 24. ACI 308.26R-02 25. ACI 308.27R-02 26. ACI 308.28R-02 27. ACI 308.29R-02 28. ACI 308.30R-02 29. ACI 308.31R-02 30. ACI 308.32R-02 31. ACI 308.33R-02 32. ACI 308.34R-02 33. ACI 308.35R-02 34. ACI 308.36R-02 35. ACI 308.37R-02 36. ACI 308.38R-02 37. ACI 308.39R-02 38. ACI 308.40R-02 39. ACI 308.41R-02 40. ACI 308.42R-02 41. ACI 308.43R-02 42. ACI 308.44R-02 43. ACI 308.45R-02 44. ACI 308.46R-02 45. ACI 308.47R-02 46. ACI 308.48R-02 47. ACI 308.49R-02 48. ACI 308.50R-02 49. ACI 308.51R-02 50. ACI 308.52R-02 51. ACI 308.53R-02 52. ACI 308.54R-02 53. ACI 308.55R-02 54. ACI 308.56R-02 55. ACI 308.57R-02 56. ACI 308.58R-02 57. ACI 308.59R-02 58. ACI 308.60R-02 59. ACI 308.61R-02 60. ACI 308.62R-02 61. ACI 308.63R-02 62. ACI 308.64R-02 63. ACI 308.65R-02 64. ACI 308.66R-02 65. ACI 308.67R-02 66. ACI 308.68R-02 67. ACI 308.69R-02 68. ACI 308.70R-02 69. ACI 308.71R-02 70. ACI 308.72R-02 71. ACI 308.73R-02 72. ACI 308.74R-02 73. ACI 308.75R-02 74. ACI 308.76R-02 75. ACI 308.77R-02 76. ACI 308.78R-02 77. ACI 308.79R-02 78. ACI 308.80R-02 79. ACI 308.81R-02 80. ACI 308.82R-02 81. ACI 308.83R-02 82. ACI 308.84R-02 83. ACI 308.85R-02 84. ACI 308.86R-02 85. ACI 308.87R-02 86. ACI 308.88R-02 87. ACI 308.89R-02 88. ACI 308.90R-02 89. ACI 308.91R-02 90. ACI 308.92R-02 91. ACI 308.93R-02 92. ACI 308.94R-02 93. ACI 308.95R-02 94. ACI 308.96R-02 95. ACI 308.97R-02 96. ACI 308.98R-02 97. ACI 308.99R-02 98. ACI 308.100R-02 99. ACI 308.101R-02 100. ACI 308.102R-02 101. ACI 308.103R-02 102. ACI 308.104R-02 103. ACI 308.105R-02 104. ACI 308.106R-02 105. ACI 308.107R-02 106. ACI 308.108R-02 107. ACI 308.109R-02 108. ACI 308.110R-02 109. ACI 308.111R-02 110. ACI 308.112R-02 111. ACI 308.113R-02 112. ACI 308.114R-02 113. ACI 308.115R-02 114. ACI 308.116R-02 115. ACI 308.117R-02 116. ACI 308.118R-02 117. ACI 308.119R-02 118. ACI 308.120R-02 119. ACI 308.121R-02 120. ACI 308.122R-02 121. ACI 308.123R-02 122. ACI 308.124R-02 123. ACI 308.125R-02 124. ACI 308.126R-02 125. ACI 308.127R-02 126. ACI 308.128R-02 127. ACI 308.129R-02 128. ACI 308.130R-02 129. ACI 308.131R-02 130. ACI 308.132R-02 131. ACI 308.133R-02 132. ACI 308.134R-02 133. ACI 308.135R-02 134. ACI 308.136R-02 135. ACI 308.137R-02 136. ACI 308.138R-02 137. ACI 308.139R-02 138. ACI 308.140R-02 139. ACI 308.141R-02 140. ACI 308.142R-02 141. ACI 308.143R-02 142. ACI 308.144R-02 143. ACI 308.145R-02 144. ACI 308.146R-02 145. ACI 308.147R-02 146. ACI 308.148R-02 147. ACI 308.149R-02 148. ACI 308.150R-02 149. ACI 308.151R-02 150. ACI 308.152R-02 151. ACI 308.153R-02 152. ACI 308.154R-02 153. ACI 308.155R-02 154. ACI 308.156R-02 155. ACI 308.157R-02 156. ACI 308.158R-02 157. ACI 308.159R-02 158. ACI 308.160R-02 159. ACI 308.161R-02 160. ACI 308.162R-02 161. ACI 308.163R-02 162. ACI 308.164R-02 163. ACI 308.165R-02 164. ACI 308.166R-02 165. ACI 308.167R-02 166. ACI 308.168R-02 167. ACI 308.169R-02 168. ACI 308.170R-02 169. ACI 308.171R-02 170. ACI 308.172R-02 171. ACI 308.173R-02 172. ACI 308.174R-02 173. ACI 308.175R-02 174. ACI 308.176R-02 175. ACI 308.177R-02 176. ACI 308.178R-02 177. ACI 308.179R-02 178. ACI 308.180R-02 179. ACI 308.181R-02 180. ACI 308.182R-02 181. ACI 308.183R-02 182. ACI 308.184R-02 183. ACI

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SECTION A-A

.200 X 45.0° TYP

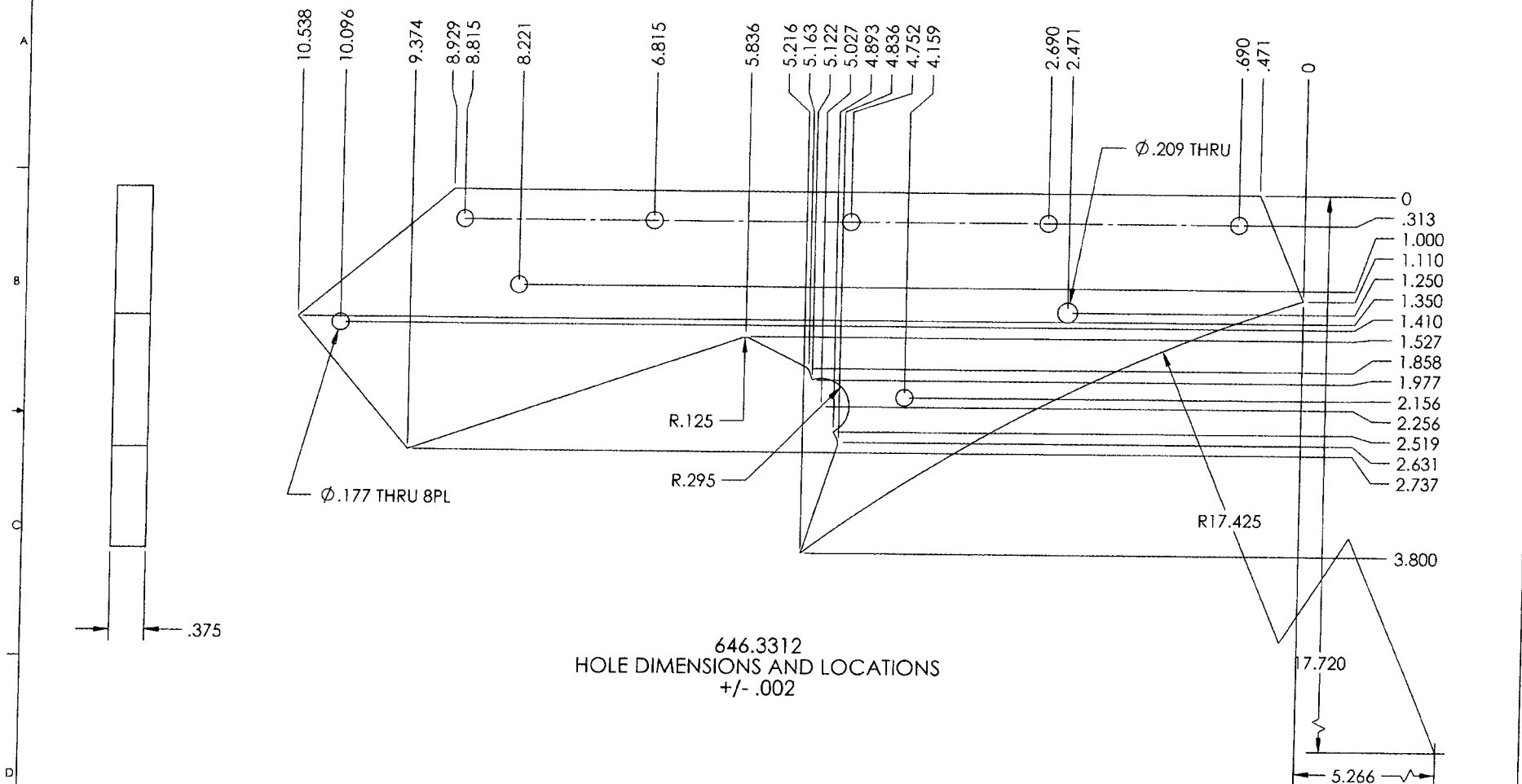


SECTION B-B

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UPPER CUTTER ASSY	
ORIGINAL DATE: 08-26-09 DRAWN BY: T. HUFF CHECKED BY: P. BRAYCO DATE: 08-26-09 CONFIRMED BY:	SHEET: B PART CODE: 071M26 SCALE: NONE
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	QTY: 100 PART NO: 646.3300 REV: N/C SHEET: 3 OF 8

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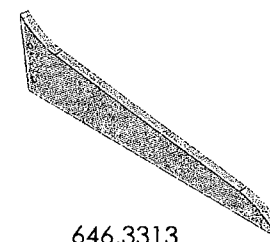
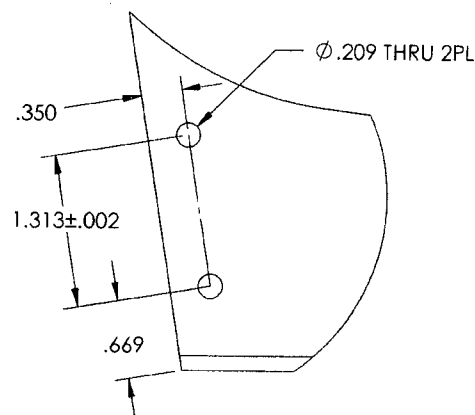
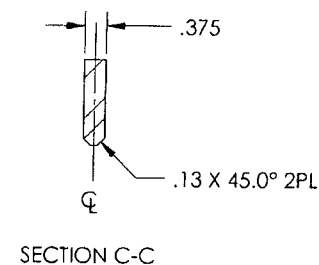
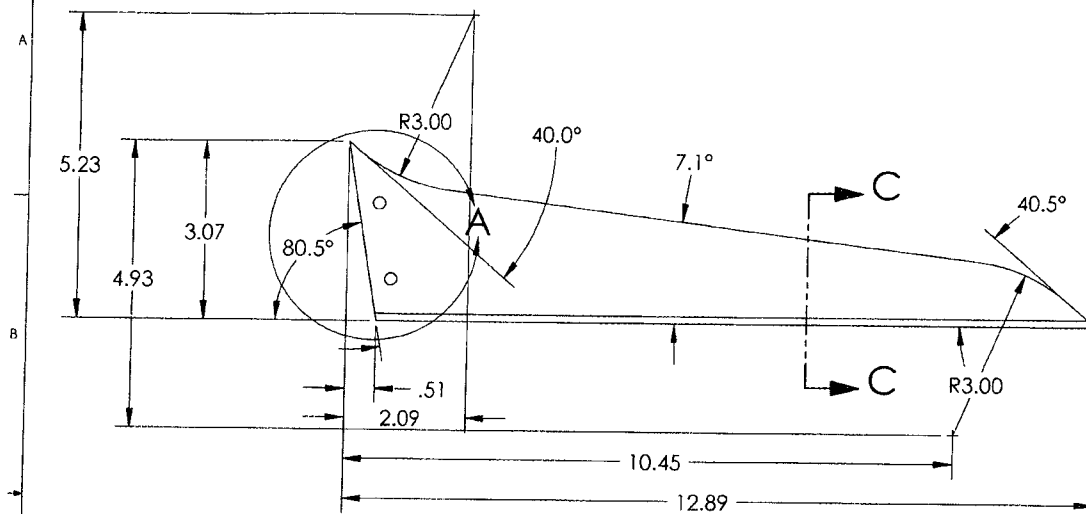
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



OPERATIONAL DATE: 08-21-08 Dwg. Date: 08-21-08 Dwg. By: J. HUFF Dwg. Check: P. HUFF Dwg. Appr: P. HUFF Dwg. Date: 08-21-08 Contract No.:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE .001 FRACTIONS ARE 1/16 ANGLES 2.5		SCALE: NONE	SHEET: 4 OF 8

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

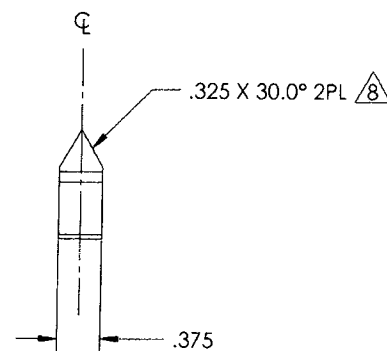
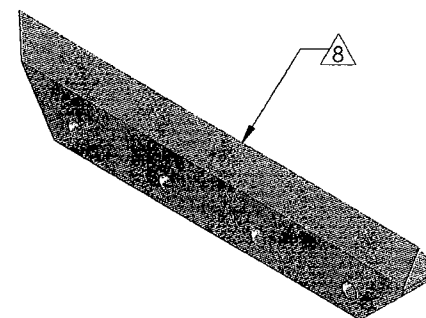
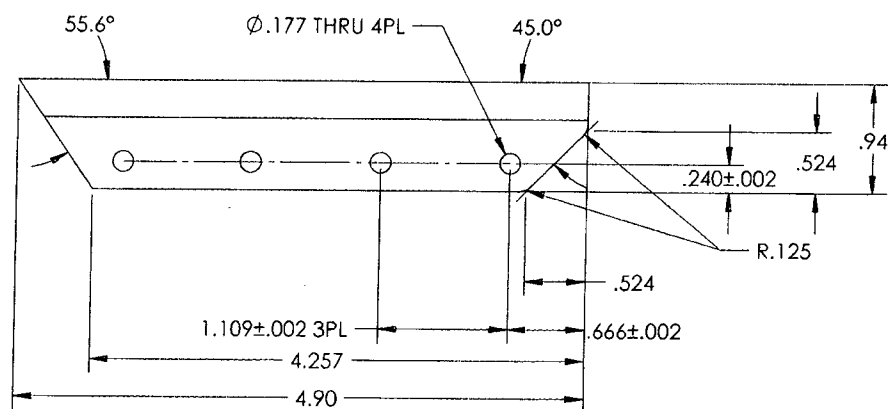
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE (MM-DD-YY) 06-26-06 DRAWN BY J. BRAY CHECKED BY J. BRAY DESIGNED BY J. BRAY DATE 06-26-06 DRAWN BY J. BRAY		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACES DECIMALS ± .01 2 PLACES DECIMALS ± .005 1 PLACE ± .5		SHEET 07M26 SCALE NONE	REV. N/C SHEET 5 OF 8
646.3300		UPPER CUTTER ASSY	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

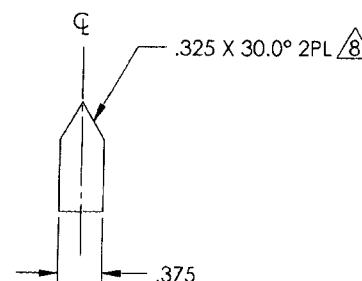
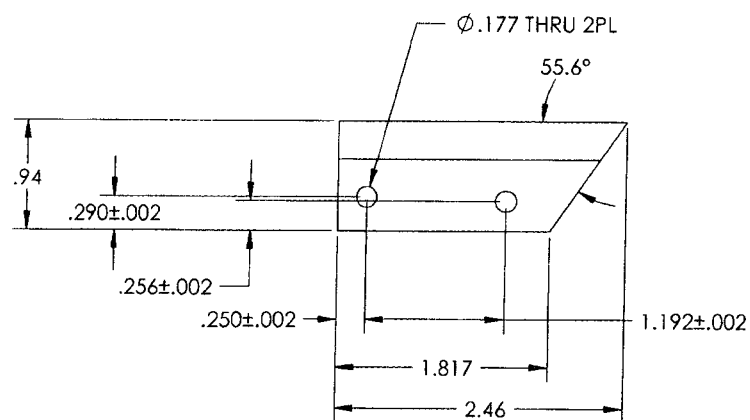
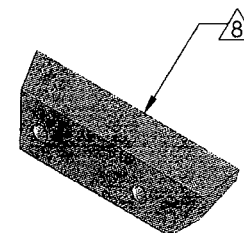


646.3314

ORIGINAL DATE 08-26-08		APICAL INDUSTRIES	
DRAWN BY J. HUP		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. RAYVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. RAYVO		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACE DECIMALS ±.01 2. PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV N/C
SCALE NONE		DWG. NO. 646.3300	SHEET 6 OF 8

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

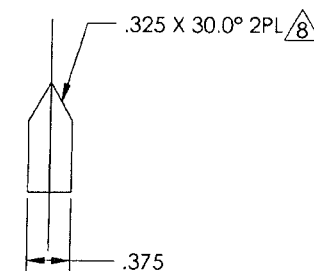
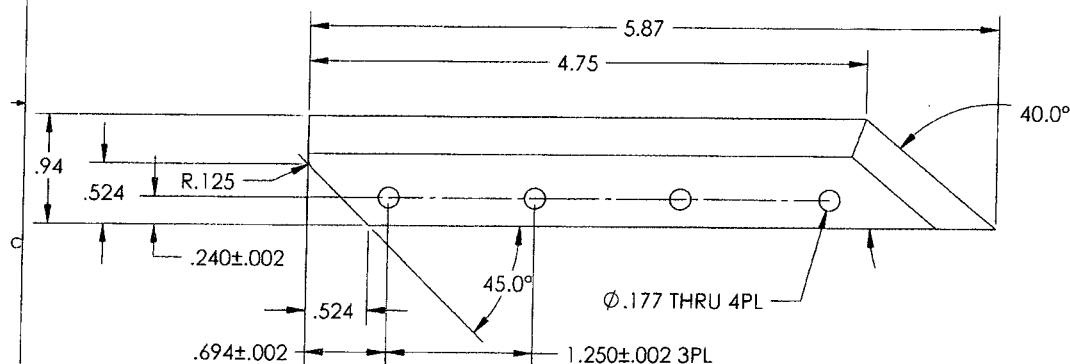
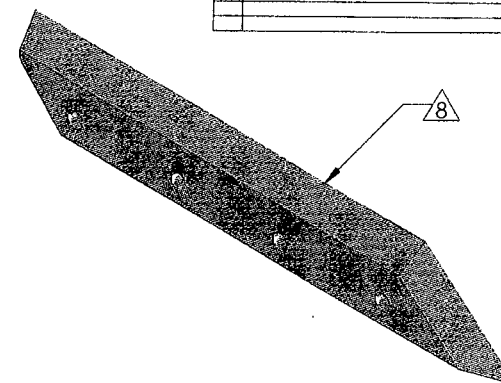


646.3315

ORIGINAL DATE 08-26-08		APICAL INDUSTRIES	
DESIGNED BY S. HUI	DRAWN BY D. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 05-26-08 CONTRACT NO.		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REF. CAGE CODE DWG. NO. B 07M26 646.3300	REV. N/C
SCALE NONE		SHEET 7 OF 8	

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REVISIONS			
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646.3316

ORIGINAL DATE 10-24-08		APICAL INDUSTRIES	
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CHECKED BY P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		UPPER CUTTER ASSY	
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SCALE: NONE		SHEET 8 OF 8	